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**A SIMPLE ANALYSIS OF THE
SWAGE AUTOFRETTAGE PROCESS**

PETER C. T. CHEN

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**US ARMY ARMAMENT RESEARCH,
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INTRODUCTION

To increase the maximum pressure a cylinder can contain without plastic deformation and to enhance its fatigue life, residual stresses are often produced in cylinders through autofrettage (ref 1). Many solutions have been reported for the hydraulic autofrettage process (refs 2-6). The thick-walled cylinders were subjected to uniform internal pressure of sufficient magnitude to cause plastic deformation and then the pressure was removed.

A more economical way of producing residual stresses in thick-walled cylinders is the swage autofrettage process. This process is carried out by a swage, the diameter of which is greater than the inner diameter of the cylinder. This swage is driven through the cylinder from one end to the other. A rigorous analysis of this process is difficult. In this report a simple analysis of the swage autofrettage process is presented. The swage mandrel and the cylinder are made of tungsten carbide and steel, respectively. A two-dimensional plane-strain analysis is used to determine the contact pressure at different locations of the cylinder as a function of interference. The deformation and stress distribution during autofrettage are obtained. At the end of the autofrettage process, the permanent bore enlargement and residual stresses are calculated.

ELASTIC SWAGING

The swage mandrel is assumed to be a short cylindrical bar driven through a long thick-walled cylinder from one end to the other. The diameter of the mandrel ($2c$) is a constant, but the inner and outer diameters ($2a$ and $2b$) of the tube are variables. When the difference between c and a is positive, we have interference I . For small values of interference, the stress state in the

References are listed at the end of this report.

swaging assembly is elastic. The stresses and displacement in the tube are

$$\begin{aligned}\frac{\sigma_r}{\sigma_\theta} &= \frac{p}{1 - a^2/b^2} \left[\frac{a^2}{b^2} \mp \frac{a^2}{r^2} \right] \\ \frac{u}{r} &= \frac{p/E}{1 - a^2/b^2} \left[(1+\nu) \frac{a^2}{r^2} + (1-\nu-2\nu^2) \frac{a^2}{b^2} \right]\end{aligned}\quad (1)$$

and in the mandrel

$$\begin{aligned}\sigma_r &= \sigma_\theta = -p \\ u/r &= -(1-\nu_1-2\nu_1^2)p/E_1\end{aligned}\quad (2)$$

where E , ν , and E_1 , ν_1 are the material constants of the tube and mandrel, respectively. At the interface, u_a (tube) - u_a (mandrel) = I by the compatibility requirement. The interference pressure p is a function of the interference I given by

$$p = \frac{EI}{a} (1 - \frac{a^2}{b^2}) / [(1+\nu) + (1-\nu-2\nu^2) \frac{a^2}{b^2} + (1-\nu_1-2\nu_1^2)(1 - \frac{a^2}{b^2})E/E_1] \quad (3)$$

For sufficiently large values of the interference, the stresses in the tube reach the yield limit. Assuming that Tresca's yield condition governs the behavior of the material, the tube first becomes plastic at the interference when the stresses satisfy $\sigma_\theta - \sigma_r = \sigma_0$, where σ_0 is the initial tensile yield stress. The solution for the critical interference pressure to cause incipient plastic deformation is

$$p^* = \frac{1}{2} \sigma_0 (1 - a^2/b^2) \quad (4)$$

and it follows from Eq. (3) that the interference for the onset of plastic flow is

$$I^* = \frac{\sigma_0}{E} \frac{a}{2} [(1+\nu) + (1-\nu-2\nu^2) \frac{a^2}{b^2} + (1-\nu_1-2\nu_1^2)(1 - \frac{a^2}{b^2})E/E_1] \quad (5)$$

which reduces to $I^* = (1-\nu^2) a \sigma_0/E$ for the special case ($E_1 = E$, $\nu_1 = \nu$).

SWAGING BEYOND THE ELASTIC LIMIT

For values of interference larger than that given by Eq. (5), a plastic zone forms in the tube, so that for $a \leq r \leq \rho$ the tube is plastic, while for $\rho \leq r \leq b$ the tube material is still in an elastic state. The elastic-plastic interface radius ρ is a function of the interference I .

We assume that the steel tube is elastically-ideally plastic, obeying Tresca's yield criterion and the associated flow theory, but the tungsten carbide mandrel is elastic. This assumption is justified because the strength ratio of tungsten carbide to steel is about three. For loading beyond the elastic limit, the closed-form solution has been found by Koiter (ref 2). The expressions for the stresses and displacement in the tube are

$$\begin{aligned} \sigma_r/\sigma_0 &= \frac{1}{2} \left(1 + \frac{\rho^2}{b^2} \right) - \log \frac{\rho}{r}, \quad \text{in } (a \leq r \leq \rho) \\ \sigma_\theta/\sigma_0 & \end{aligned} \quad (6)$$

$$\begin{aligned} \sigma_r/\sigma_0 &= \frac{1}{2} \left(\frac{\rho^2}{b^2} - \frac{\rho^2}{r^2} \right), \quad \text{in } (\rho \leq r \leq b) \\ \sigma_\theta/\sigma_0 & \end{aligned} \quad (7)$$

$$\frac{E}{\sigma_0} \frac{u}{r} = (1-2\nu)(1+\nu) \frac{\sigma_r}{\sigma_0} + (1-\nu^2) \frac{\rho^2}{r^2} \quad (8)$$

where the elastic-plastic interface ρ is related to the internal pressure p by

$$p/\sigma_0 = \frac{1}{2} (1 - \rho^2/b^2) + \log(\rho/a) \quad (9)$$

For swaging beyond the elastic limit, the compatibility requires u_a (tube) - u_a (mandrel) = I at the interface, i.e.,

$$\frac{E}{\sigma_0} \frac{I}{a} = (1-\nu^2) \frac{\rho^2}{a^2} - \frac{\rho}{\sigma_0} [(1-2\nu)(1+\nu) - (1-\nu_1-2\nu_1^2) \frac{E}{E_1}] \quad (10)$$

Equations (9) and (10) give us a parametric representation of relating p to I through the parameter ρ . The contact pressure at different locations can thus be determined as a function of the interference I .

UNLOADING ANALYSIS

After swaging, the permanent bore enlargement and residual stresses can be calculated by an unloading analysis. Let a double prime denote a component in the residual state, i.e., $\sigma_{\theta}'' = \sigma_{\theta} + \sigma_{\theta}'$. Assuming elastic unloading, the solution is given by

$$\frac{\sigma_r'}{\sigma_{\theta}'} = \frac{p}{b^2/a^2 - 1} \left[\pm \frac{b^2}{r^2} - 1 \right] \quad (11)$$

$$E u'/r = - [(1-\nu) + (1+\nu)b^2/r^2]p/(b^2/a^2 - 1) \quad (12)$$

In a recent paper (ref 6), this author presented a more rigorous elastic-plastic unloading analysis based on a new theoretical model considering the Bauschinger and hardening effects during unloading. This mode is a very good representation for the material behavior of the high strength steel used in gun tubes (ref 7). Taking into account the Bauschinger effect (f) and the strain-hardening during unloading (m'), we have obtained a closed-form solution. On unloading, yielding will occur for $a \leq r < \rho'$ with $\rho' < \rho$. The stresses in the reverse yielding zone ($a \leq r < \rho'$) are given by

$$\sigma_r'/\sigma_0 = p/\sigma_0 - \frac{1}{2}\beta_2'(1+f)(\rho'/a)^2(1-a^2/r^2) - (1-\beta_2')(1+f)\log(r/a) \quad (13)$$

$$\sigma_{\theta}'/\sigma_0 = \sigma_r'/\sigma_0 - (1+f)[1 + \beta_2'(\rho'^2/r^2 - 1)] \quad (14)$$

where

$$\beta_1' = (1-m')/[m' + \frac{\sqrt{3}}{2} \frac{(1-m')}{(1-\nu^2)}] \quad , \quad \beta_2' = m'\beta_1'/(1-m') \quad (15)$$

The stresses in the elastic zone ($\rho' \leq r \leq b$) are

$$\begin{aligned} \sigma_r'/\sigma_0 &= \frac{1}{2}(1+f)[\pm (\rho'/r)^2 - (\rho'/b)^2] \\ \sigma_{\theta}'/\sigma_0 & \end{aligned} \quad (16)$$

The displacement for the entire tube ($a \leq r \leq b$) is

$$(E\sigma_0)u'/r = (1-2\nu)(1+\nu)(\sigma_r'/\sigma_0) - (1-\nu^2)(1+f)(\rho'/r)^2 \quad (17)$$

The residual stresses and displacement are found by addition

$$\sigma_r'' = \sigma_r + \sigma_r' , \quad \sigma_\theta'' = \sigma_\theta + \sigma_\theta' \quad \text{and} \quad u'' = u + u' \quad (18)$$

NUMERICAL RESULTS AND DISCUSSION

The material constants used in the calculations are $E = 206.84$ GPa, $\nu = 0.3$, $\sigma_0 = 1.29$ GPa, $m' = 0.3$ for the high strength steel, and $E_1 = 610.19$ GPa, $\nu_1 = 0.258$ for the tungsten carbide mandrel. The radius of the mandrel is a constant $c = 58.42$ mm, but the thickness of the tube varies along the axial direction with the inner radius (a) increasing slightly and the external radius (b) tapering more rapidly. The values of a and b at four typical sections are $a_j = 56.96, 57.82, 57.99, 58.63$ mm and $b_j = 157.50, 106.75, 83.00, 83.00$ mm, for $j = 1, 2, 3, 4$, respectively. The corresponding values of wall ratio are $b_j/a_j = 2.765, 1.846, 1.431, 1.42$ at four sections. The interference during swaging (I) is the positive difference between c and a . The values of I at four sections are $I_j = 1.46, 0.60, 0.43, -0.21$ mm for $j = 1, 2, 3, 4$. The negative value of I_4 means that there is no contact between the mandrel and the tube. For the positive values of interference, the contact pressure and the stress distribution during swaging can be obtained using the methods presented previously in this report. The information after swaging can be obtained by the unloading analysis also presented previously.

The numerical results are presented in terms of the dimensionless quantities defined by

$$\begin{aligned} \bar{r} &= r/a , \quad \bar{p} = p/\sigma_0 , \quad \bar{\sigma}_\theta = \sigma_\theta/\sigma_0 \\ \bar{I} &= (E/\sigma_0)I/a , \quad \bar{u} = (E/\sigma_0)u/a , \quad \text{etc.} \end{aligned} \quad (19)$$

The contact pressure (\bar{p}) and hoop stress ($\bar{\sigma}_\theta$) at the interface are presented as functions of the interference (\bar{I}) in Figures 1, 2, and 3 for wall ratios $b/a =$

2.765, 1.846, 1.431, respectively. The results for swaging within and beyond the elastic limit are included. The pressure is a monotonous increasing function of the interference, but the maximum value of hoop stress occurs at the onset of plastic flow as shown in the dotted curves. Initial yielding occurs at $\bar{I}^* = 0.774, 0.799, 0.830$, and fully plastic flow occurs at $\bar{I}^{**} = 6.638, 2.909, 1.751$ for three different wall ratios, respectively. The actual values of interference (\bar{I}) at the three chosen sections are $\bar{I}_1 = 4.10, \bar{I}_2 = 1.66, \bar{I}_3 = 1.19$. These values indicate that swaging is partially plastic at these sections in zones 1, 2, and 3. The corresponding locations of elastic-plastic boundary are given by $p/a = 2.2001, 1.4196, 1.19205$, and the amounts of overstrain are 68, 49.6, and 44.6 percent, respectively. Also shown in Figures 1, 2, and 3 are the values of contact pressure ($\bar{p} = 0.972, 0.555, 0.671$) and the hoop stress at the interface $\bar{\sigma}_\theta = 1 - \bar{p}$. The distributions of hoop stresses during swaging are shown in Figure 4 for typical sections in three zones. The maximum value of hoop stress occurs at the elastic-plastic boundary. The information for the displacement and stresses after swaging can be obtained by an unloading analysis. The distributions of residual hoop stresses are shown in Figure 5 for the chosen sections in three zones. Elastic unloading analysis is justified in zone 3, but reverse yieldings occur in zones 1 and 2 with $p'/a = 1.305$ and 1.014 , respectively. Finally, the distributions of residual displacements (\bar{u}'') at typical sections in three zones are presented in Figure 6. Also shown in this figure are the experimental data at the bore. The agreement between the calculated and experimental data is excellent in zone 1, but not so good in zones 2 and 3. This suggests that a more refined analysis is needed for sections with smaller wall ratios. An investigation based on the finite element method is being conducted and the results will be reported in the near future.

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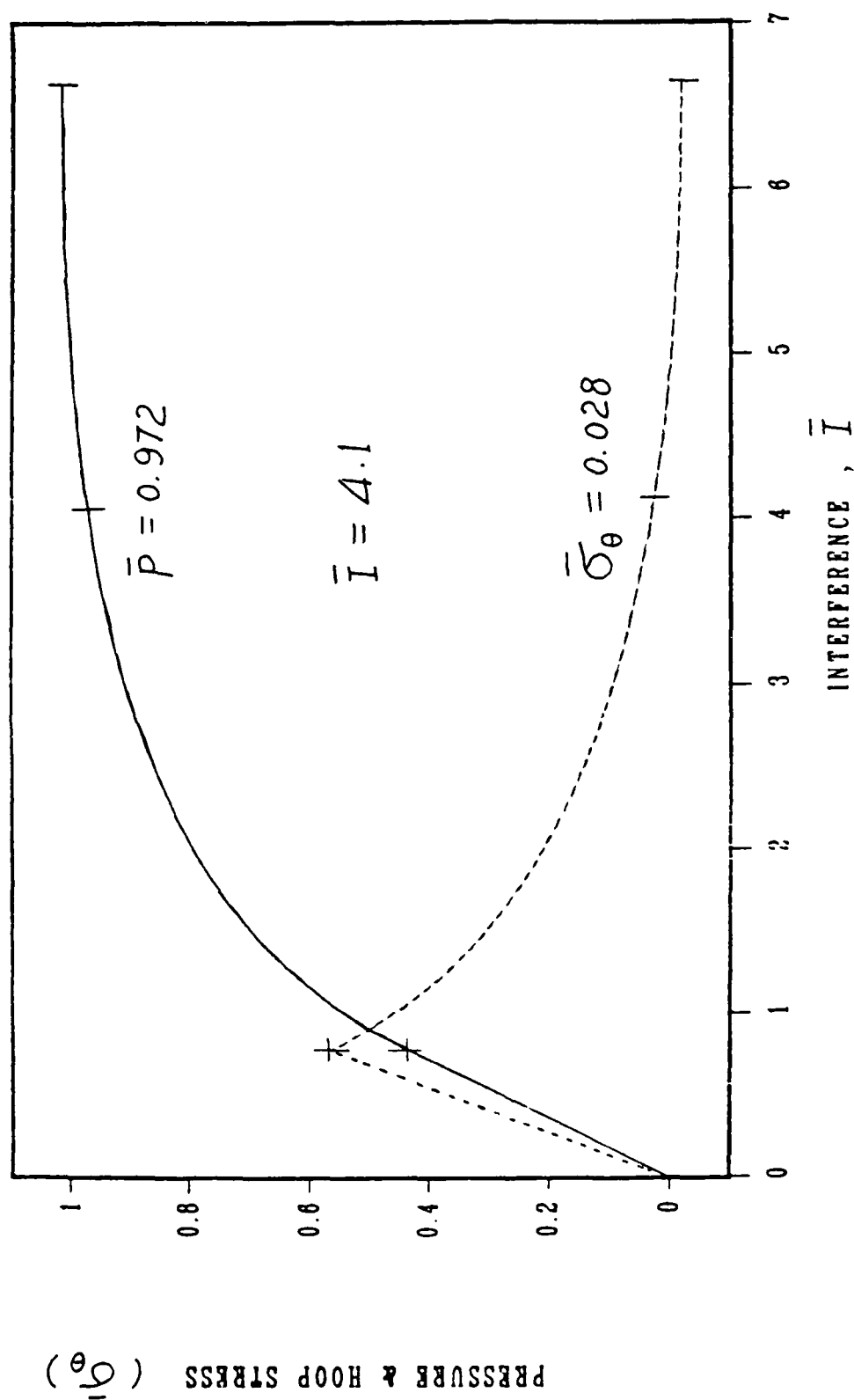


Figure 1. Contact pressure and hoop stress at the interface as functions of interference for a section in zone 1.

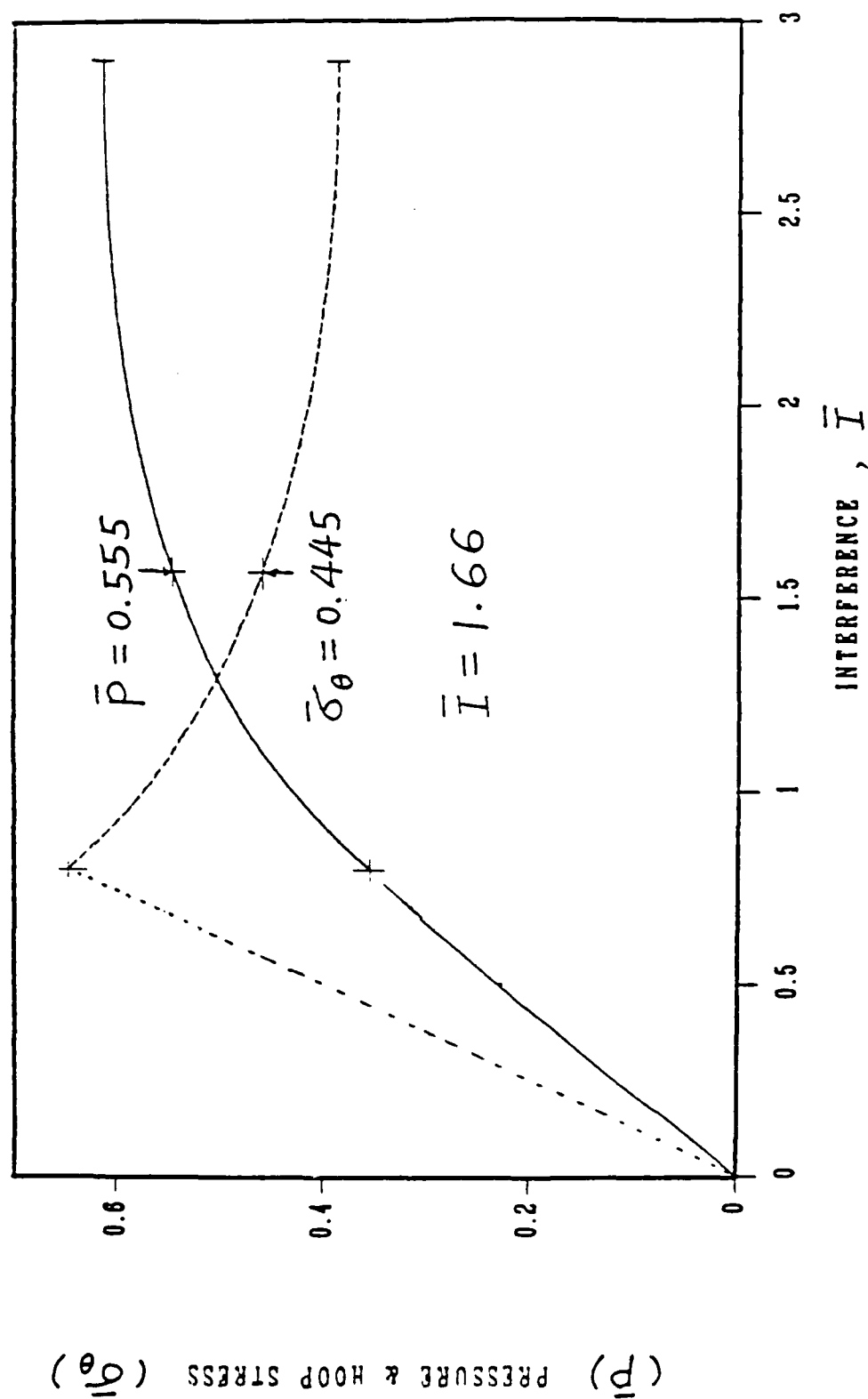


Figure 2. Contact pressure and hoop stress at the interface as functions of interference for a section in zone 2.

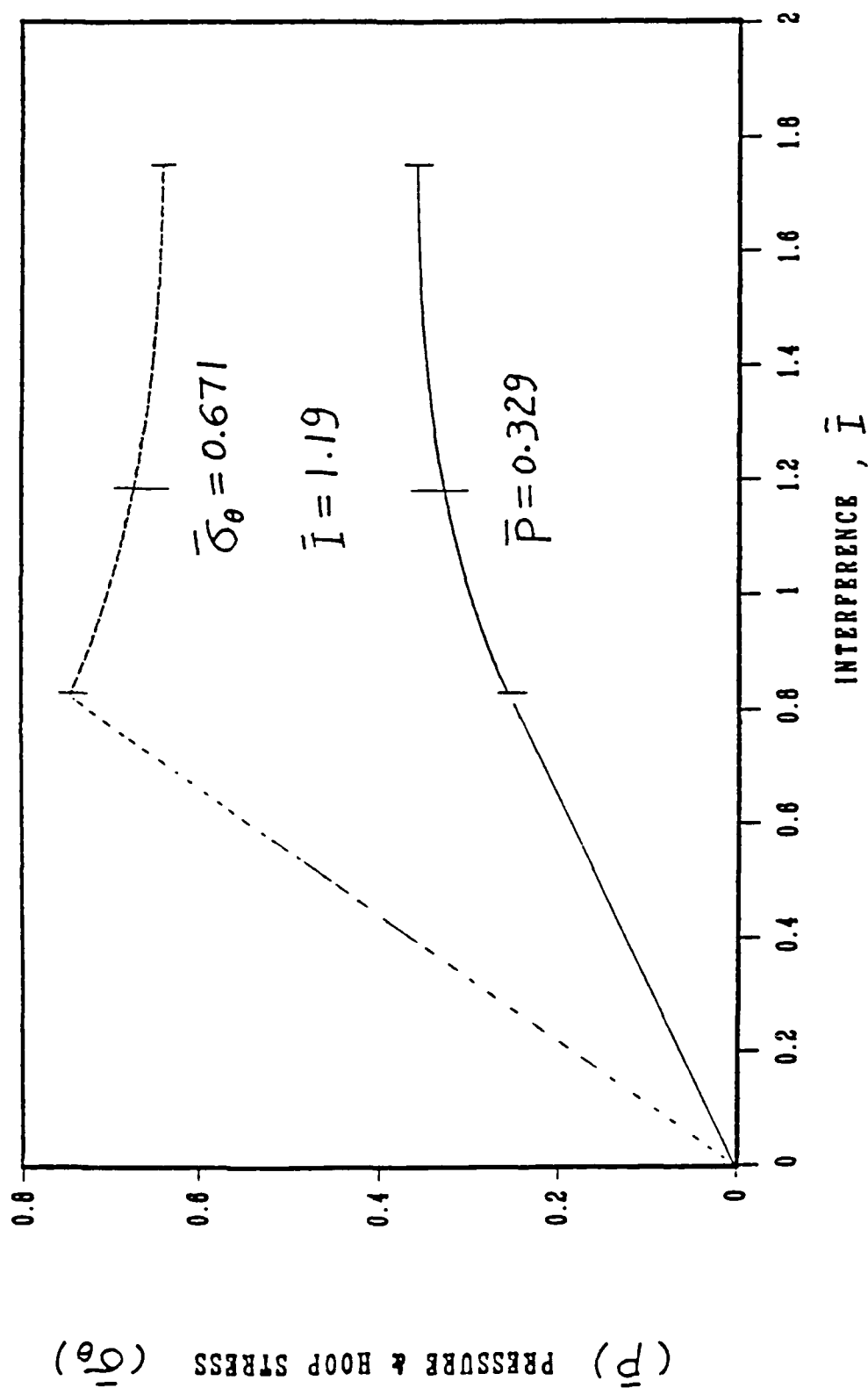


Figure 3. Contact pressure and hoop stress at the interface as functions of interference for a section in zone 3.

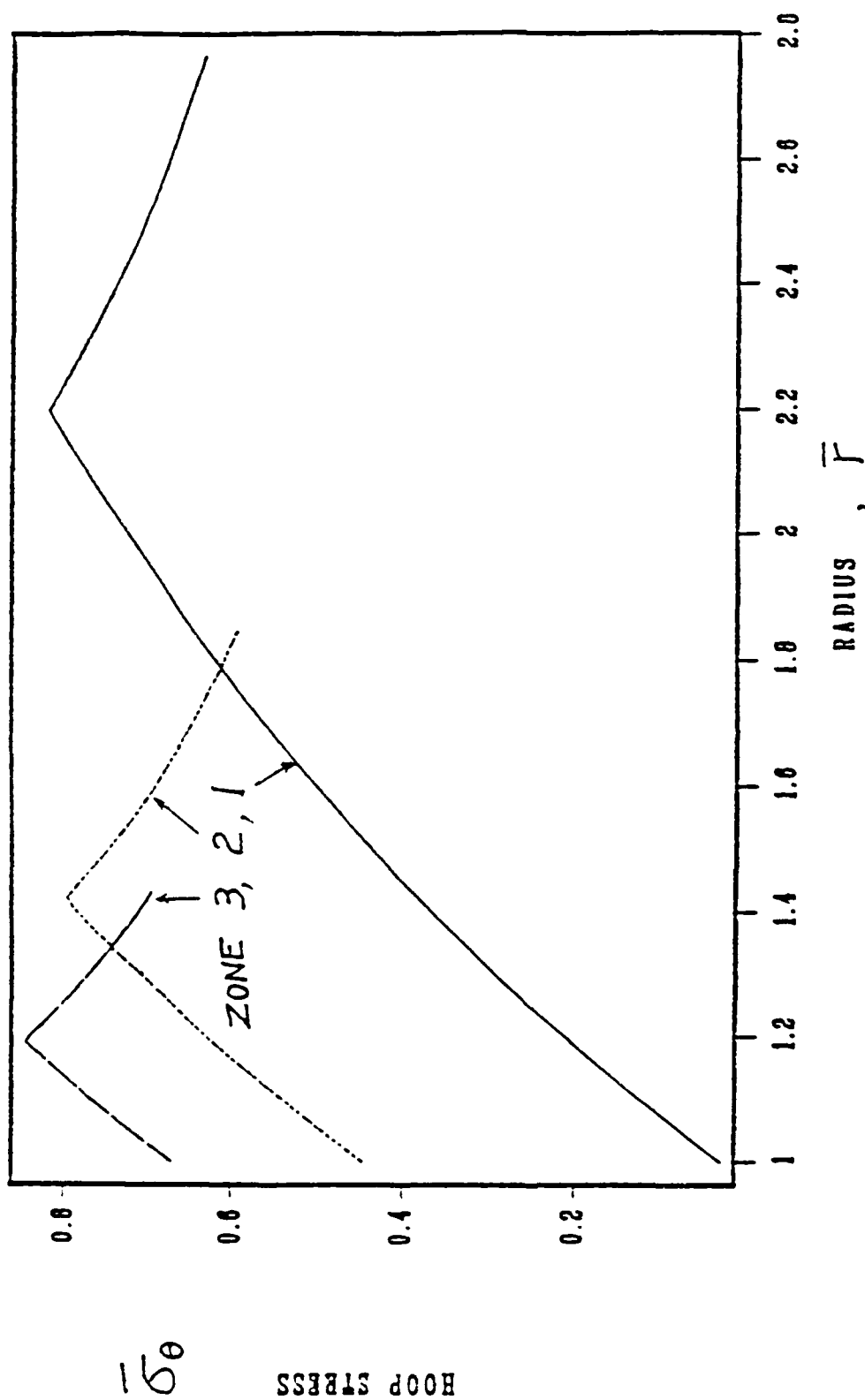


Figure 4. The hoop stress distributions at three sections.

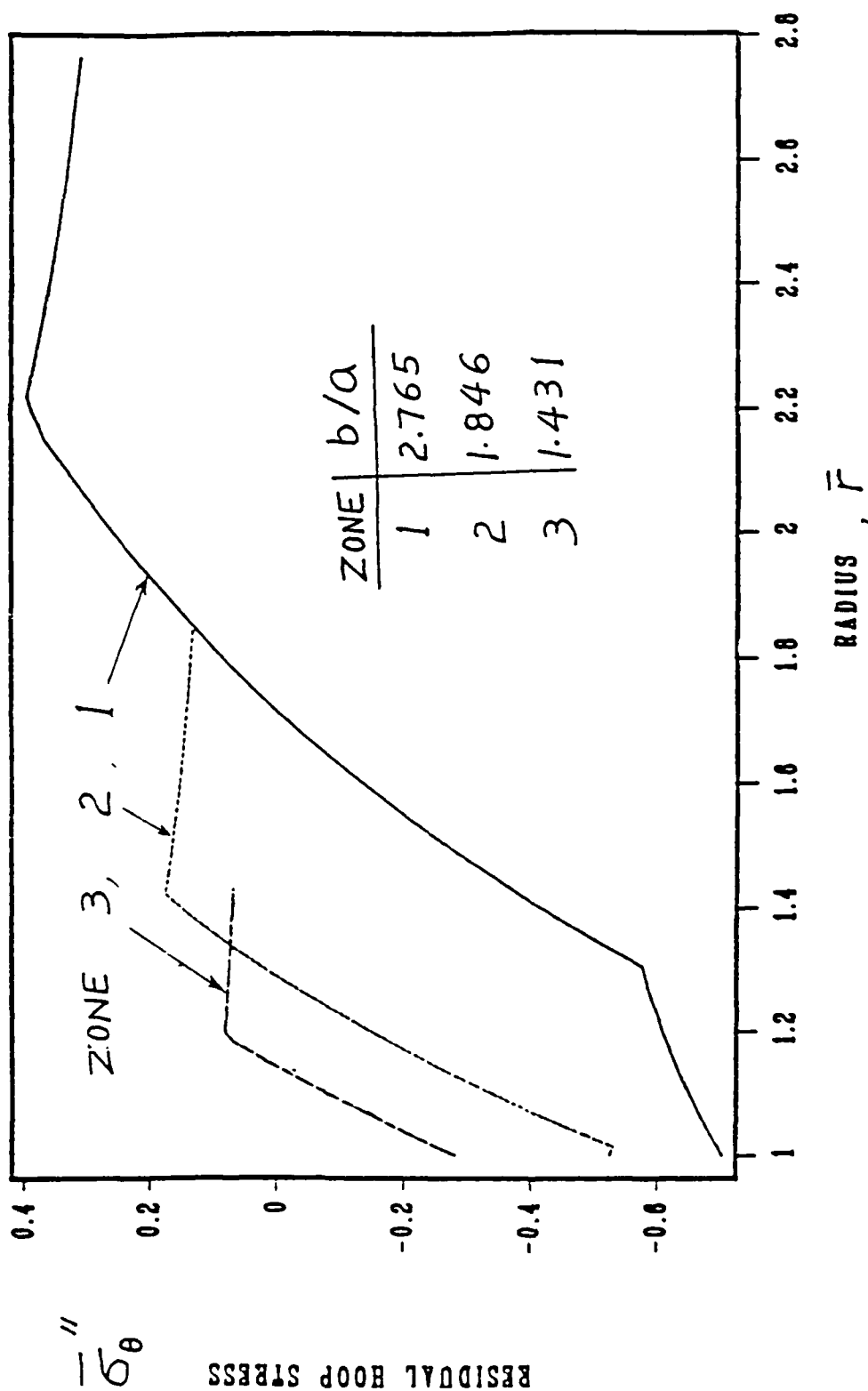


Figure 5. The distributions of residual hoop stresses at three sections.

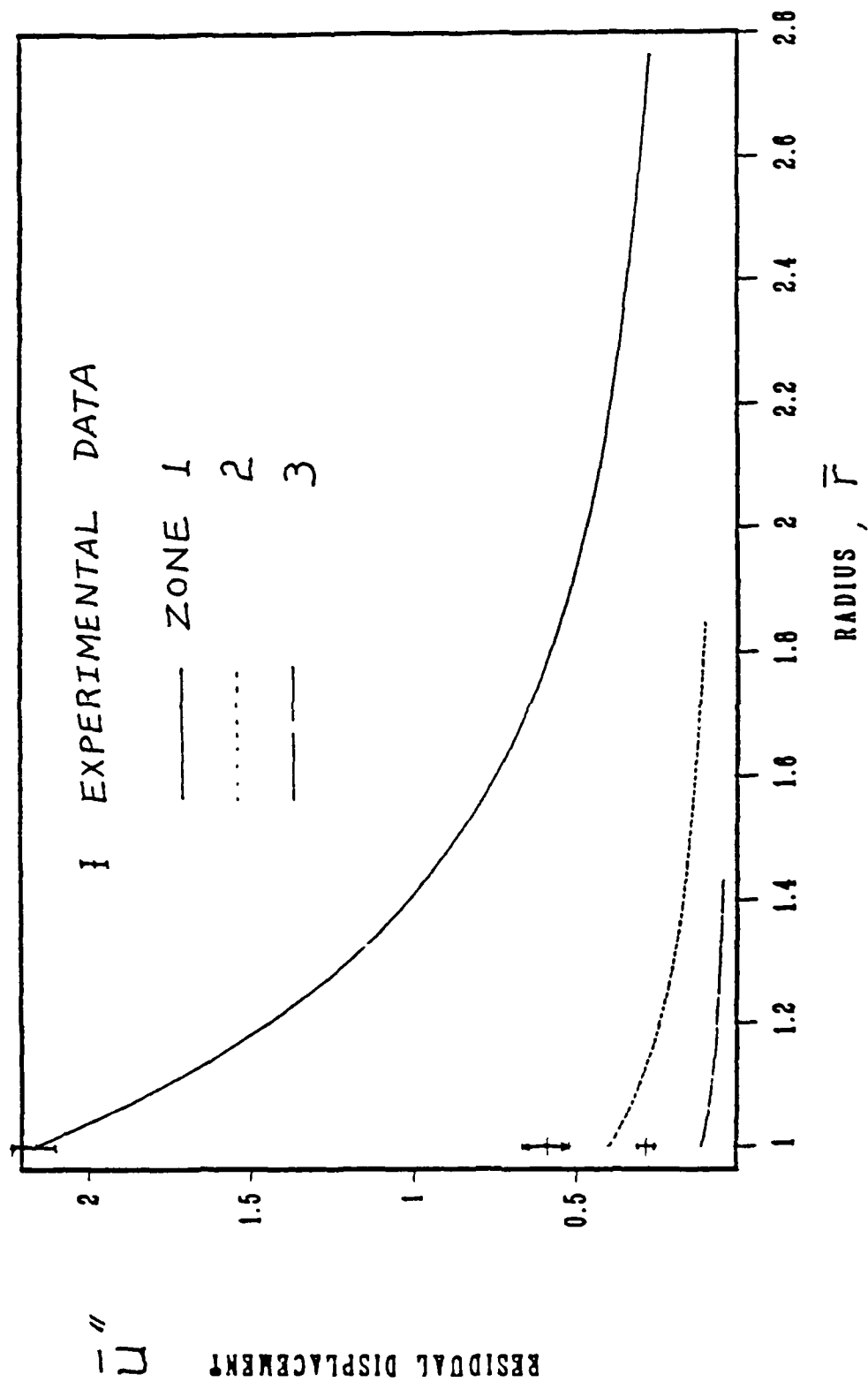


Figure 6. The distributions of residual displacements at three sections.

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